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D3914-041

Job Sheet 200261



Part No: D3914-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/9/19

Job Tracking No:

Due Date: 10/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	10/2/19		0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	10/2/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		DAS
							QC 9 - 43		43
							QC 9 - 50		9-80
							QC 9 - 9		
120	QC 5	1 pcs	10/2/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		DAS
							QC 5 - 49		43
							QC 5 - 51		9-80
							QC 5 - 58		

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						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
130 Powdercoat - 4 Black Sand - B4B	1 pcs	10/2/19	0.00	0.40		Powdercoat - 1 - B4B	
START: 12:40 OUT: 3:30 FINISH: 1:10. 135 QC 3 1 pcs 10/2/19 0.00 0.00						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
						QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
140 Handfinish - 3-1- WingWalk- B4B	1 pcs	10/2/19	0.00	0.80		Handfinish - 3 - 1 - B4B	
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
						QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
150 QC 3	1 pcs	10/2/19	0.00	0.00			

BL 14-9-23.

BEB 19-09-23

BEB 19-09-23.

DAS
59
9-89DAS
59
9-89

SEP 25 2019

						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
160	Packaging 3-1 - Stock - B4B	1	10/2/19	0.00	0.00	Packaging 3 - 1 - B4B	
	pcs					Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	BEB19-09-25
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 -	

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				B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	1	10/2/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Weld per dwg A/R S.S. rod Batch M139015 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld
 Descriptions: hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on
 basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure
 to place mesh correctly on lid, check with label plate before tacking mesh***

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 *** mask sides of hinge prior to powdercoat***

135 - QC3- Inspect Part Finish

140 - Wing Walk as per dwg QSI005 4.4 Batch 5209362 1- Mask data plate and apply wing walk on outside surface of
 mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand
 area for label, apply label ***

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location:

170 - QC21- Final Inspection - Work Order Release

MU# 011929

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	<u>5200407</u>
D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	<u>5207850</u>
D3914-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	<u>5208655</u>
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	<u>5193147</u>
D4018-5	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1	<u>5210656</u>
D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	100-Large Fab - Basket - 1	<u>5208015</u>
D4021-3	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	<u>5172801</u>
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	<u>5211287</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	87	0
	D3914-1	2	12	0
	D3914-7	2	8	0
	D4016-3	3	57	0
	D4018-5	9	62	0
	D4020-5	1	8	0
	D4021-3	1	24	0
	D4035-043	2	28	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐
Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐ ☐ ☐
Material ☐ ☐ ☐ ☐ ☐
Product Improvement ☐ ☐ ☐ ☐ ☐
Process Improvement ☐ ☐ ☐ ☐ ☐
Human Factors ☐ ☐ ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced ☐ ☐ ☐ ☐ ☐
Bending ☐ ☐ ☐ ☐ ☐
Crushing ☐ ☐ ☐ ☐ ☐
Cracks ☐ ☐ ☐ ☐ ☐
Crimp/kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ ☐
Marks/Chatter ☐ ☐ ☐ ☐ ☐
Mislabeled ☐ ☐ ☐ ☐ ☐
Other/Details: _____

Contamination ☐ ☐ ☐ ☐ ☐
Misaligned/off center ☐ ☐ ☐ ☐ ☐
BOM/Route ☐ ☐ ☐ ☐ ☐
Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐
Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐
Drill Holes ☐ ☐ ☐ ☐ ☐
Fit/Function ☐ ☐ ☐ ☐ ☐

Power Loss/Surge ☐ ☐ ☐ ☐ ☐
Folio/Program ☐ ☐ ☐ ☐ ☐
Grain Direction ☐ ☐ ☐ ☐ ☐
Weld ☐ ☐ ☐ ☐ ☐
Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐
Out of Sequence ☐ ☐ ☐ ☐ ☐
Off-set/Set-up ☐ ☐ ☐ ☐ ☐
Positioned Wrong ☐ ☐ ☐ ☐ ☐
Outside Tolerance ☐ ☐ ☐ ☐ ☐
Drawing ☐ ☐ ☐ ☐ ☐
Finish ☐ ☐ ☐ ☐ ☐
Part Lost/Missing ☐ ☐ ☐ ☐ ☐
Misread ☐ ☐ ☐ ☐ ☐